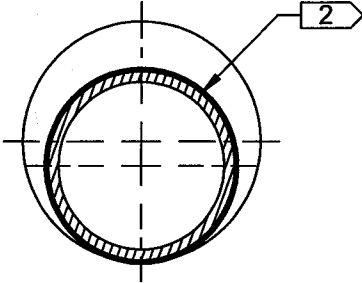
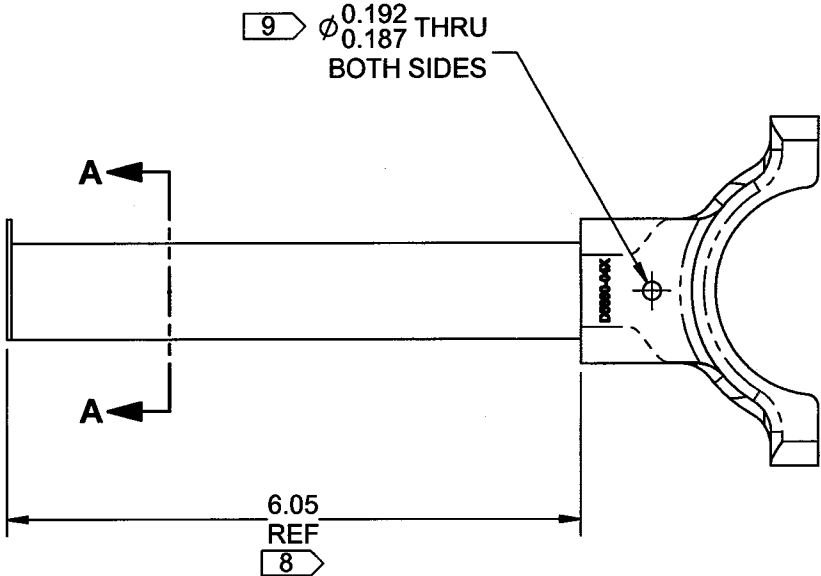
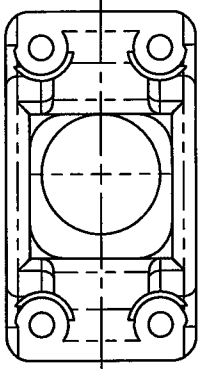


QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
X			D5880-041	STEP ASSEMBLY
	X		D5880-043	STEP ASSEMBLY
		X	D5880-045	STEP ASSEMBLY
1	1	1	D5880-051	STEP TUBE WELDMENT
1			D5880-1	SOCKET CLAMP
	1		D5880-3	SOCKET CLAMP
		1	D5880-5	SOCKET CLAMP
1	1	1	MS16562-240	SPRING PIN, SLOTTED

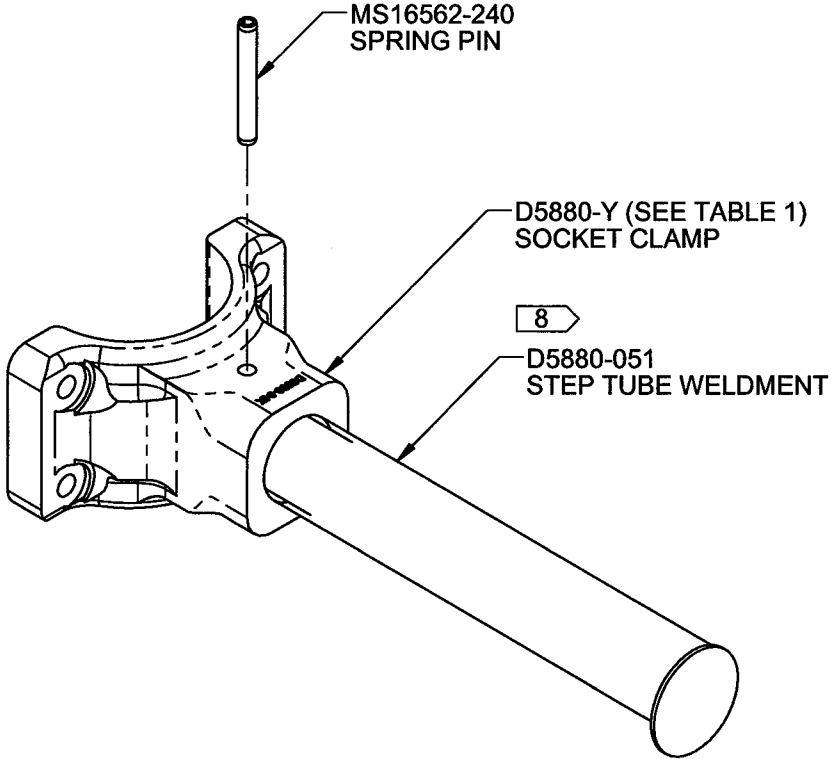
TABLE 1	
P/N "X"	D5880-Y
D5880-041	D5880-1
D5880-043	D5880-3
D5880-045	D5880-5



SECTION A-A  
SCALE 2X



D5880-04X STEP ASSEMBLY  
(DERIVED FROM AERO DESIGN P/N 62340-01)  
(SPRING PIN HIDDEN FOR CLARITY)



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: WHITE GLOSS POWDER COAT PER DART QSI 005 SECTION 4.3  
APPLY BLACK ANTI-SKID PAINT (WING WALK) ALONG THE STEP TUBE WELDMENT AS SHOWN  
PER DART QSI 005 SECTION 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER DART QSI 044
  - 7) WEIGHT: 0.92 lbs
  - 8) APPLY A THIN FILM OF 3M DP460 SCOTCH-WELD EPOXY ADHESIVE TO SOCKET AND PRESS STEP TUBE  
WELDMENT INTO SOCKET CLAMP. ENSURE STEP TUBE IS FULLY INSERTED BY CHECKING REFERENCED DIMENSION
  - 9) TRANSFER DRILL HOLE THEN INSTALL SPRING PIN AS SHOWN, AFTER PRESSING STEP TUBE INTO SOCKET CLAMP

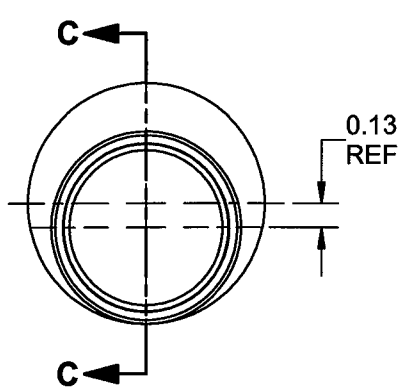
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2021 MAY 07  
43 ECR 21-157

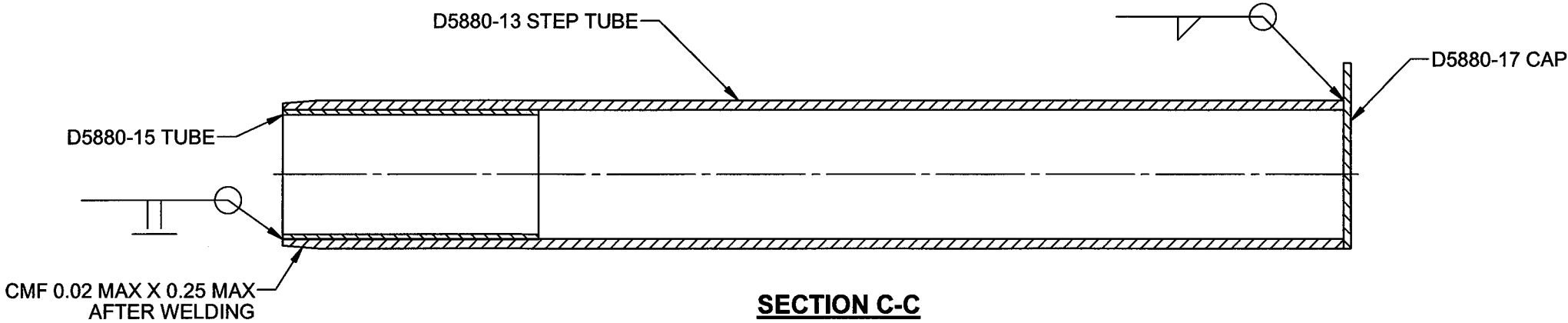
APPROVED

A	NEW ISSUE	JC	20.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO.	REV. A
MFG. APPR.	FK	D5880	SHEET 1 OF 7
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	STEP ASSEMBLY	NTS
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QTY -051	P/N	DESCRIPTION
X	D5880-051	STEP TUBE WELDMENT
1	D5880-13	STEP TUBE
1	D5880-15	TUBE
1	D5880-17	CAP



**D5880-051 STEP TUBE WELDMENT**  
(DERIVED FROM AERO DESIGN P/N 62340-04)



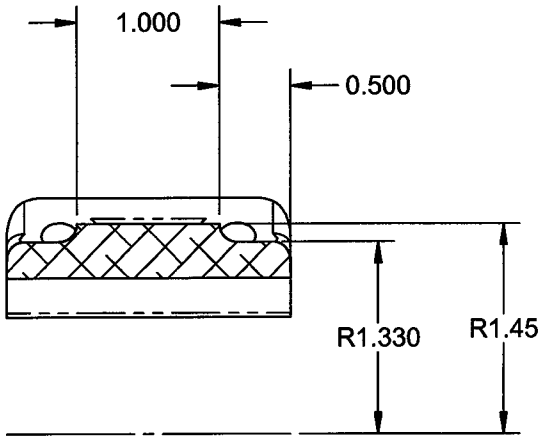
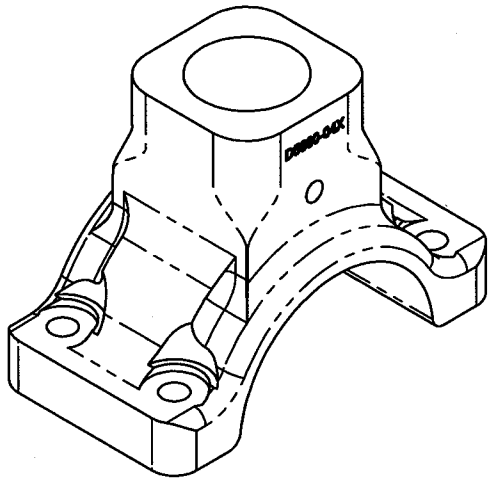
NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: PER DART QSI 044  
7) WEIGHT: 0.46 lbs  
8) WELD PER DART QSI 004. IT IS PERMISSIBLE TO BUFF OR GRIND TO CLEAN UP WELDS

RELEASED  
2021 MAY 07

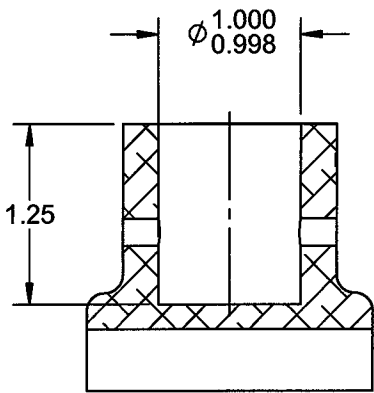
APPROVED

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. <b>D5880</b>	REV. A
MFG. APPR.	FK	SHEET 2 OF 7	
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	<b>STEP ASSEMBLY</b>	NTS
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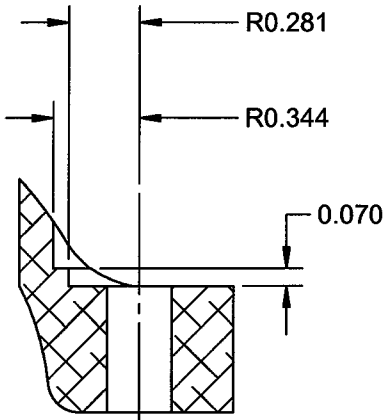
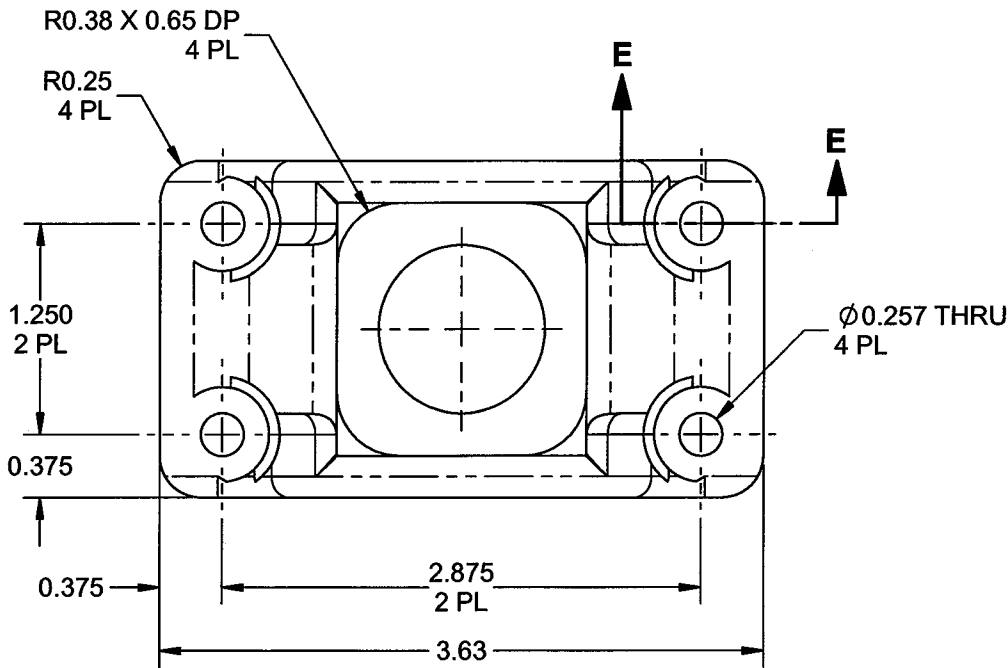
TABLE 3			
P/N "Y"	"R"	P/N IDENTIFICATION	CAD FILE
D5880-1	1.080	D5880-041	D5880-1 REV A .STEP
D5880-3	1.010	D5880-043	D5880-3 REV A .STEP
D5880-5	1.140	D5880-045	D5880-5 REV A .STEP



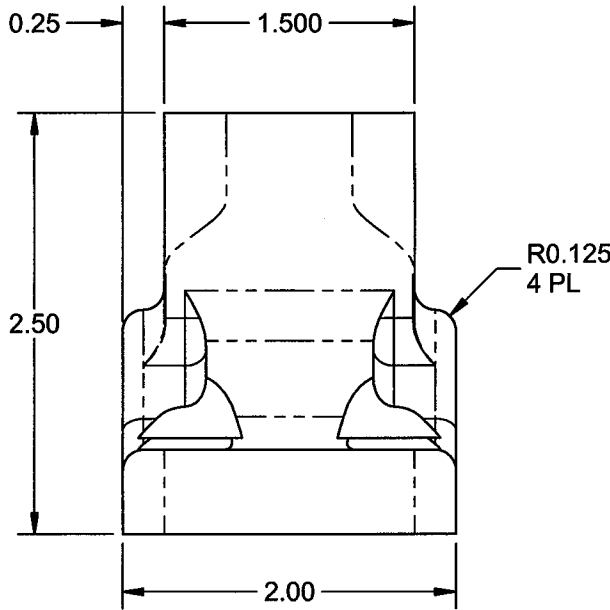
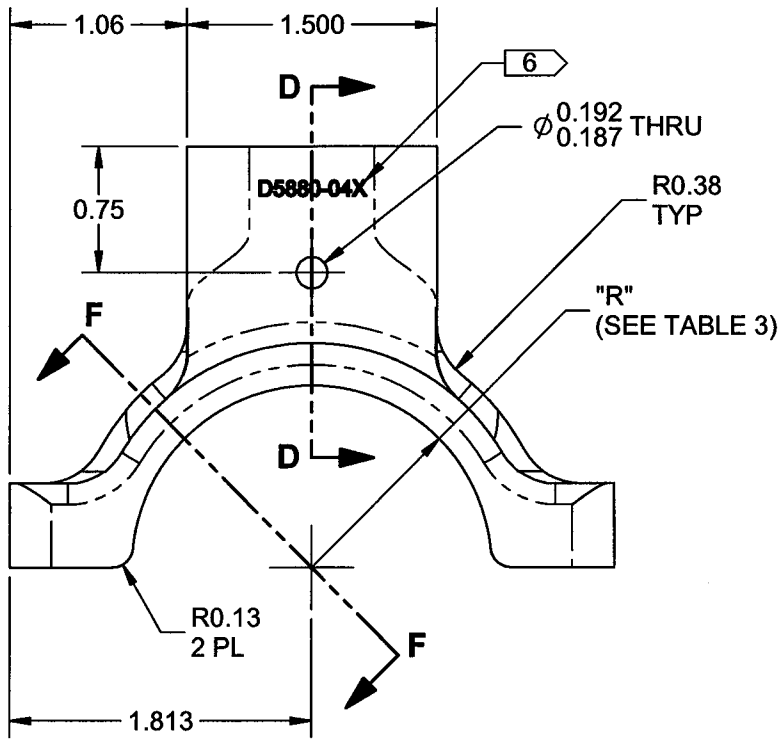
**SECTION F-F**  
2 PL



**SECTION D-D**



**SECTION E-E**  
SCALE 1.5X  
4 PL



**D5880-Y SOCKET CLAMP**  
(DERIVED FROM AERO DESIGN P/N 62340-02)

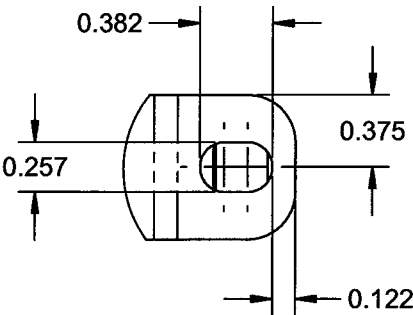
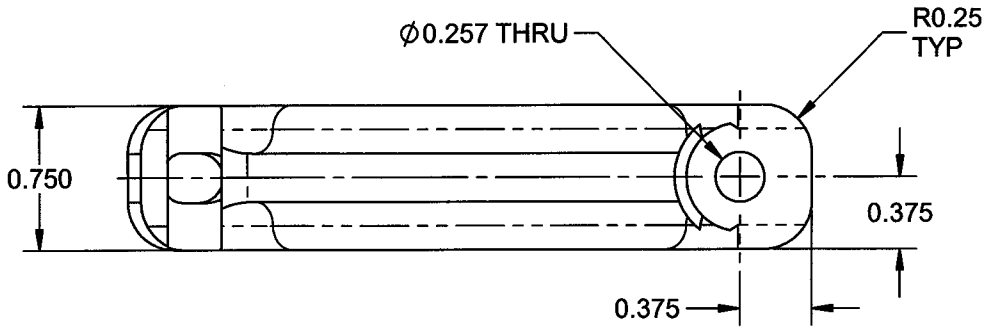
- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 SECTION 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE 3) PER DART QSI 044 SECTION 6.3  
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
  - 7) WEIGHT: 0.46 lbs
  - 8) ALL NON DIMENSIONED FEATURES WITHIN 0.030 OF CAD FILE (SEE TABLE 3)

**RELEASED**  
2021 MAY 07

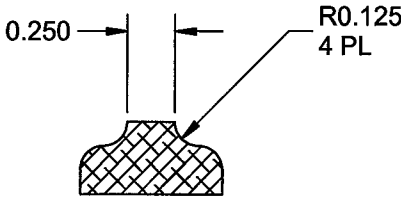
APPROVED

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SAD	DRAWING NO.	REV. A
MFG. APPR.	FK	D5880	SHEET 3 OF 7
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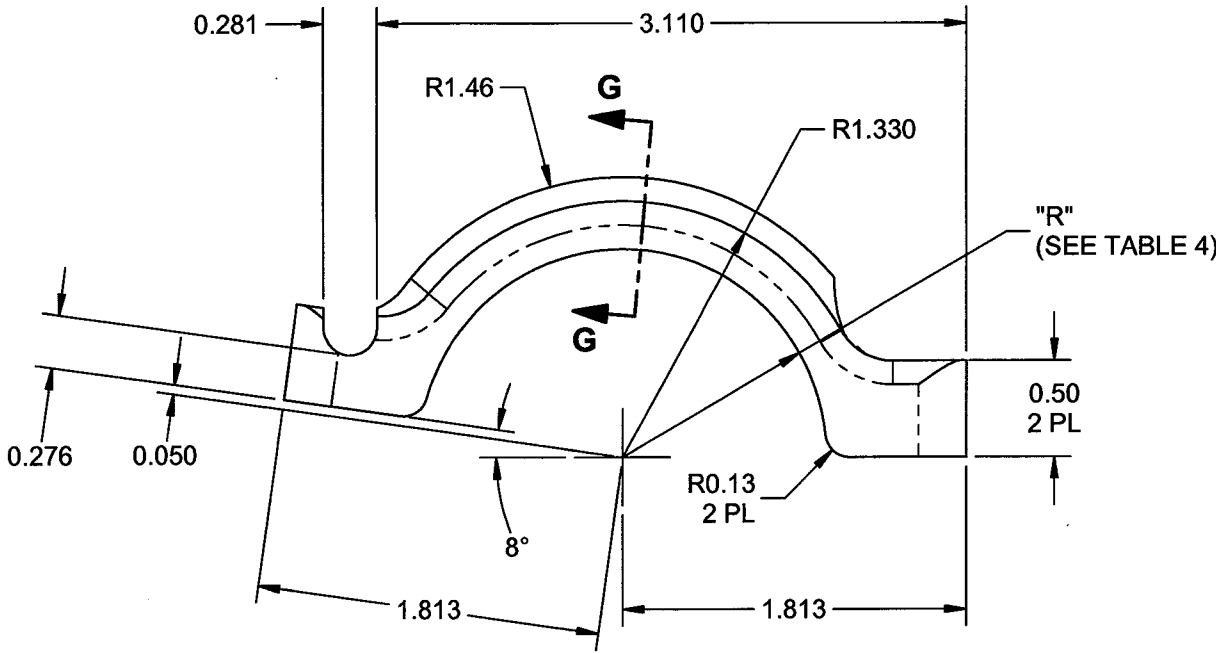
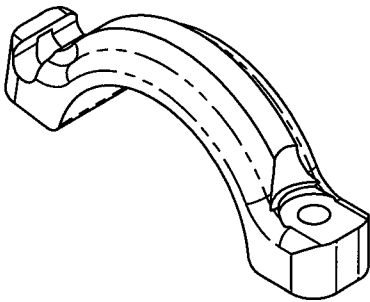
TABLE 4		
P/N "Z"	"R"	CAD FILE
D5880-7	1.080	D5880-7 REV. A .STEP
D5880-9	1.010	D5880-9 REV. A .STEP
D5880-11	1.140	D5880-11 REV. A .STEP



VIEW J-J

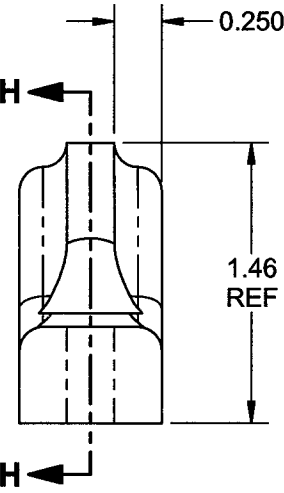


SECTION G-G

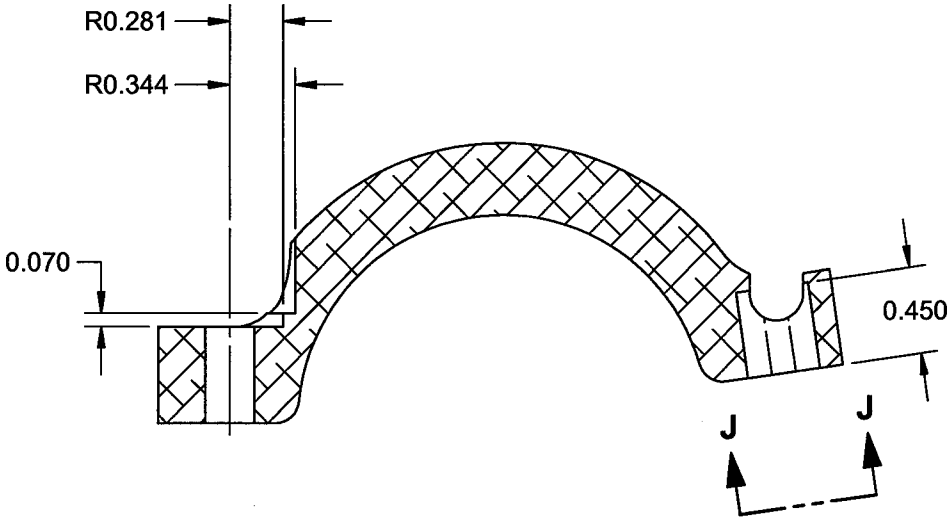


D5880-Z CLAMP

(DERIVED FROM AERO DESIGN P/N 62340-03)



SECTION H-H



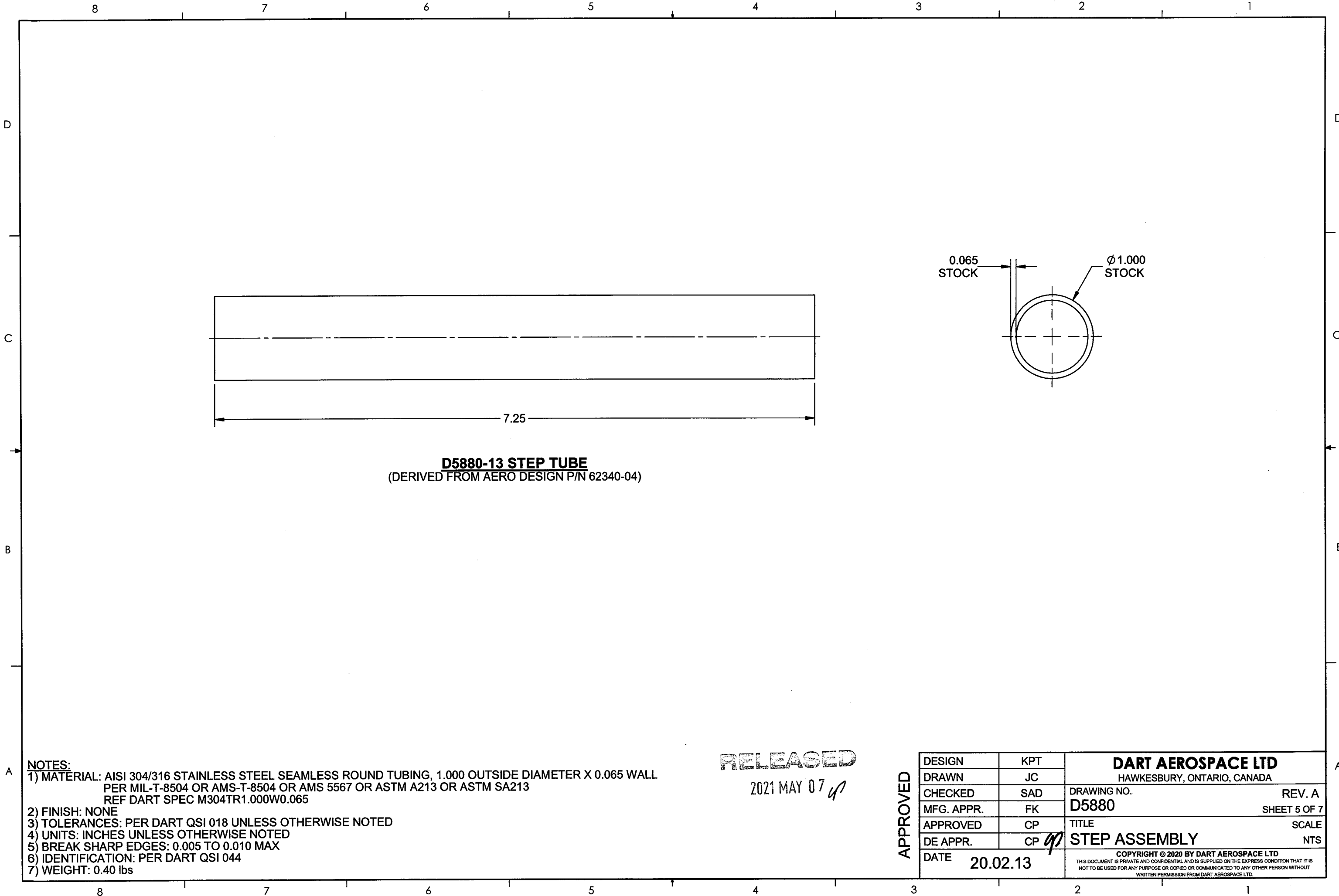
- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 SECTION 4.1  
WHITE GLOSS POWDER COAT PER DART QSI 005 SECTION 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER DART QSI 044
  - 7) WEIGHT: 0.10 lbs
  - 8) ALL NON DIMENSIONED FEATURES WITHIN 0.030 OF CAD FILE (SEE TABLE 4)

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DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. D5880	REV. A
MFG. APPR.	FK		SHEET 4 OF 7
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DE APPR.	CP <i>ap</i>	STEP ASSEMBLY	NTS
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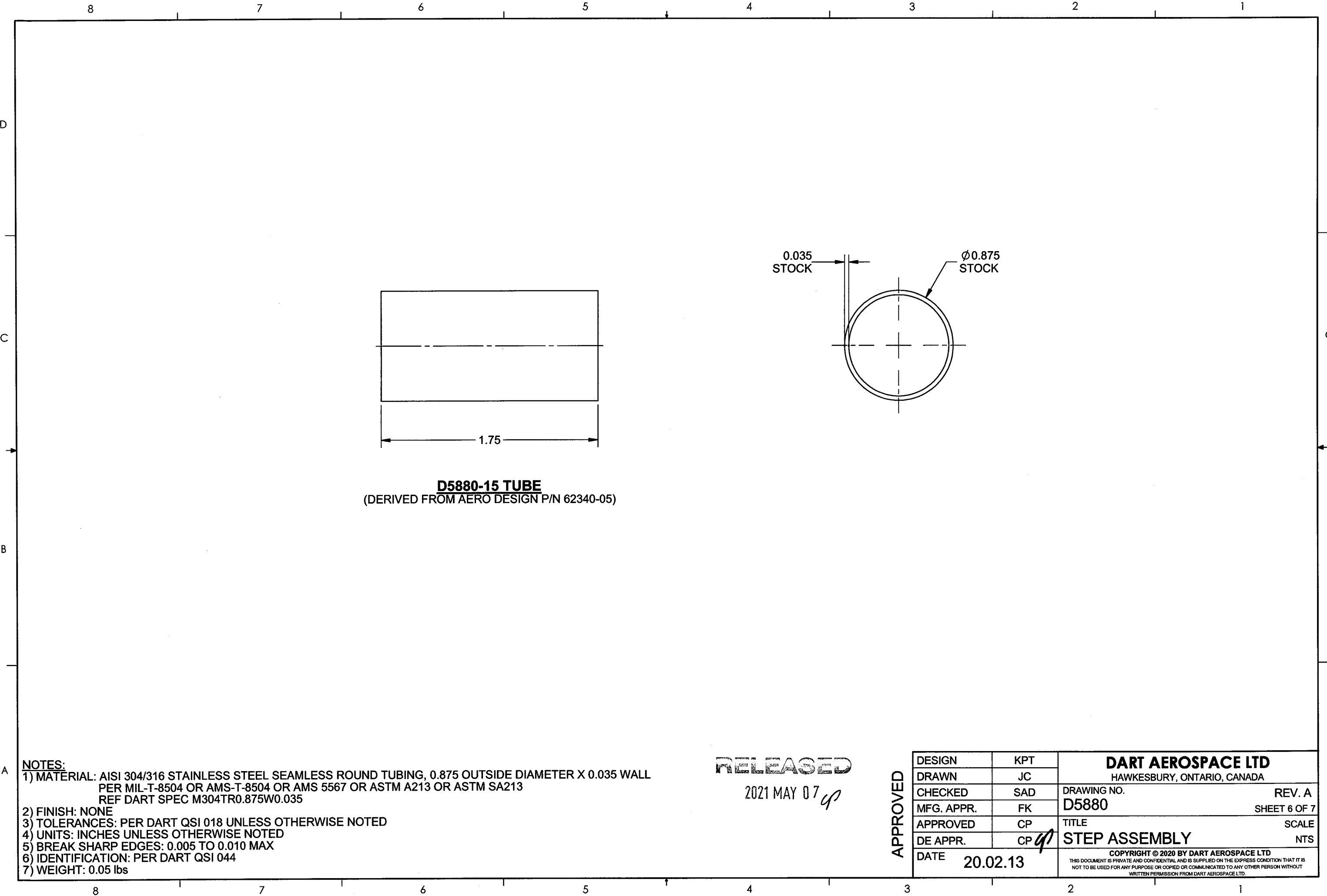
**D5880-13 STEP TUBE**  
(DERIVED FROM AERO DESIGN P/N 62340-04)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, 1.000 OUTSIDE DIAMETER X 0.065 WALL  
PER MIL-T-8504 OR AMS-T-8504 OR AMS 5567 OR ASTM A213 OR ASTM SA213  
REF DART SPEC M304TR1.000W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER DART QSI 044
  - 7) WEIGHT: 0.40 lbs

**RELEASED**  
2021 MAY 07

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DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. <b>D5880</b>	REV. A
MFG. APPR.	FK	SHEET 5 OF 7	
APPROVED	CP	TITLE	SCALE
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**D5880-15 TUBE**  
(DERIVED FROM AERO DESIGN P/N 62340-05)

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, 0.875 OUTSIDE DIAMETER X 0.035 WALL  
PER MIL-T-8504 OR AMS-T-8504 OR AMS 5567 OR ASTM A213 OR ASTM SA213  
REF DART SPEC M304TR0.875W0.035
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER DART QSI 044
  - 7) WEIGHT: 0.05 lbs

RELEASED

2021 MAY 07 *qp*

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DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. <b>D5880</b>	REV. A
MFG. APPR.	FK	SHEET 6 OF 7	
APPROVED	CP	TITLE	SCALE
DE APPR.	CP <i>qp</i>	<b>STEP ASSEMBLY</b>	NTS
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